

Date: Thursday, 8/23/2007 11:53:37 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PACKER	
Job Number : 34249		
Estimate Number : 11074		
P.O. Number : N/A	Part Number : D2974	
This Issue : 8/23/2007 S.O. No. : N/A	Drawing Number : D2974 REV. A	
Prsht Rev. : NC	Project Number : N/A	
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A	
Previous Run : 29439	Material : N/A	
Written By : <u>JA 708 23</u>	Due Date : 9/5/2007	Qty: <u>10</u> Um: Each
Checked & Approved By : <u>JA 708 23</u>		
Comment : Est A 06.05.30 New Issue EC		
Est A 06.11.20 New Issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.4200 sf(s)/Unit Total : 42000 sf(s)

5052-H32 .040 Sheet

Material: 5052 H32 sheet .040 Thick

Batch M104921

SAD

07/08/25

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

SAD

07/08/25

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/08/25

(10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD

07/08/28

60000  
 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

~~Tumble~~ Debur  
 Bend as per dwg D2974

07/09/06

8B 07/09/01

(10) 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 07/09/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:37 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PACKER

Job Number: 34249

Part Number: D2974

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Coater*  
*57/02/21 (10)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*BR* *07-09-24* *(10)*

8.0

POWDER COATING

POWDER COATING



*M104846*



*(10X)*

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*M-1* *07/09/24*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*MS* *07-09-25*



*(10)*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock *5755*

Location: *57498*

*07/09/25 (10)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



*(10)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/09/25*

Job Completion



*07-09-25*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

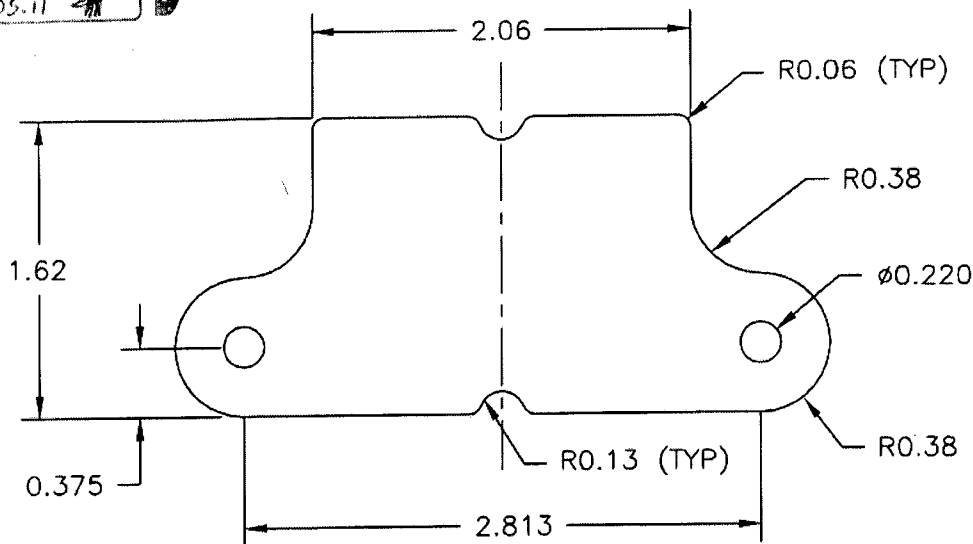
NOTE: Date & initial all entries



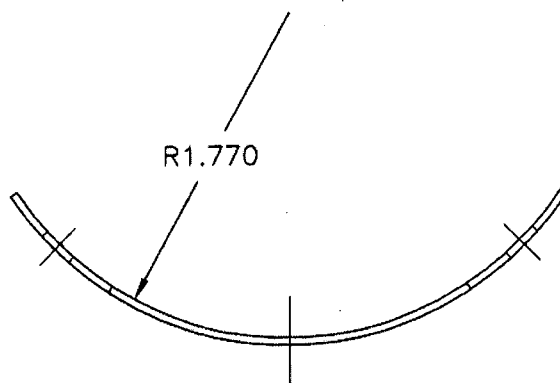
DESIGN RT	DRAWN BY RT	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2974	REV. A SHEET 1 OF 1
DATE 00.03.15		TITLE PACKER	SCALE 1:1
A	00.03.15	NEW ISSUE	

RELEASED  
00.05.11 [Signature]

FLAT PATTERN



BENDING DETAIL



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34249

BREAK ALL SHARP EDGES 0.010 TO 0.020  
MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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